

Date: Friday, 9/21/2007 12:59:43 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 34782	
Estimate Number : 10376	
P.O. Number : N/A	Part Number : D2885
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : D2885 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 32627	Material : N/A
	Due Date : 10/3/2007 Qty: 40 Um: Each
Written By : <u>JA 07.09.24</u>	
Checked & Approved By : <u>JA 07.09.24</u>	
Comment : Est A 99.10.12 New Issue EC	
Est Rev:B Now 6060-T6 06-06-23 JLM	
Est Rev:C waterjet 06-07-23 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0270 sf(s)/Unit Total: 1.0794 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.080" Thick

Batch M104921 H307-09-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2885

Dwg Rev: B H307-09-28Prog Rev: B

2-Deburr if necessary

B 07/10/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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H307-09-28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 07/10/03count

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h07/10/0948x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:59:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 34782

Part Number: D2885

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count
09/10/09 (448)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/10/09 (48)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(48)
09/10/10

Job Completion



U 09.10.09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34782
Description: Saddle Spacer		Part Number:	D2885
Inspection Dwg: D2885 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	.43	X			
0.443	+/-0.010	.443	X			
Ø0.257	+0.006/-0.001	.260	X			
R0.30	+/-0.030	.30	X			
0.679	+/-0.010	.679	X			
R0.40	+/-0.030	.40	X			
0.250	+0.030/-0.000	.250	X			
0.672	+/-0.010	.672	X			
0.521	+/-0.010	.521	X			
1.340	+/-0.010	1.340	X			
2.681	+/-0.010	2.681	X			
3.71	+/-0.030	3.70	X			
R0.38	+/-0.030	.38	X			
0.528	+/-0.010	.528	X			
0.080°	+/-0.5°					

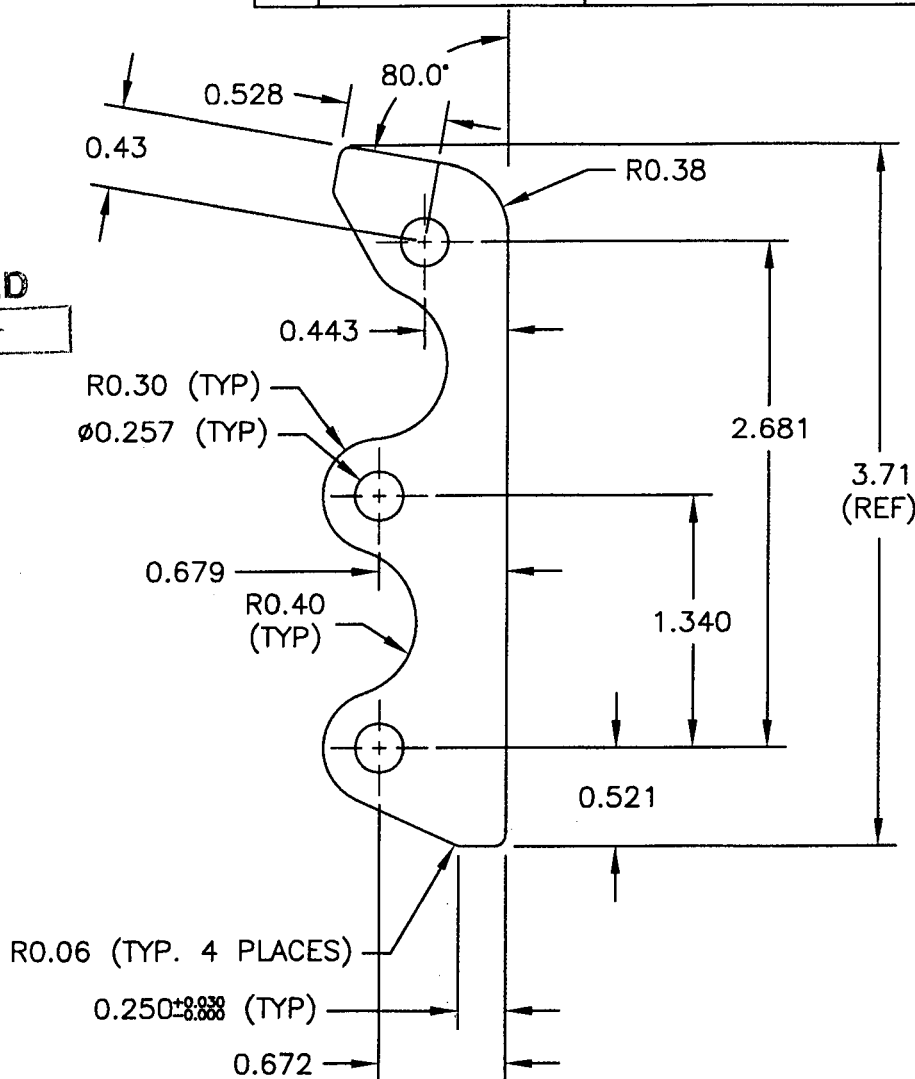
Measured by: <i>HS</i>	Audited by: <i>En</i>	Prototype Approval:	N/A
Date: <i>07-08-27</i>	Date: <i>07/08/27</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM <i>KA</i>	<i>SA</i>

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
cl. cl. 10 *[Signature]*

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34782

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